

Fixed Length Series Power Collet Chuck for Bar Machining

First & Second Operation Collet Chuck

Designed with a fixed length actuation system that ensures the collet is held stationary. Allowing the collet chuck to be used in bar feeding operations and highly accurate second operations. Klamp DHF collet chucks are suitable for collets which have a +/-0.5mm gripping range.

Fixed Length Collet

Workpiece remains in a fixed position during actuation, allowing for precise z-axis positioning. A tapered sleeve is pushed forward, compressing the collet and gripping the workpiece.

Problem Free Installation

Klamp collet chucks are provided with mounting bolts and a custom-machined drawtube connector allowing you to start using the Klamp collet chuck straight out of the box.

Quick & Easy Mounting

Klamp collet chucks mount directly to the lathe spindle or use a precision adaptor plate to ensure a consistent mounting without the need for correction. The precision fit of the Klamp collet chuck enhances the rigidity of the overall system. The need for adjustment is minimal, meaning less machine down-time.

Long Service Life

All Klamp collet chucks are case hardened, optimising the rigidity, strength and durability.

Short Body/Wide Range

DC Varibore collets allow for a compact body design maximising the lathe work envelope. Gripping capacities of the series range from 4mm to 80mm.

Fully Sealed

No grease required to operate the collet chuck. O-ring seals are incorporated within the design to prevent coolant and chip ingress.

High Speed

Direct mount design ensures high concentricity that is suitable for higher speed operations that are not appropriate for conventional 3-jaw chuck due to the negative effects of centrifugal force.

Designed for Bar Pushers/Barfeeders

Fixed-length Klamp collet chucks are designed to work with bar loaders and bar feeders by not interfering with the process of the bar feeder action.

Ultra-Fast 10 Second Collet Changes



Suitable for DC Varibore Collet Types



Klamp DHF collet chucks accept DC Varibore Collets that have the same accuracy specification as spring collets whilst maintaining a gripping range of +/- 0.5mm. Supplied with either smooth or serrated gripping surface. Serrated collets are ideal for aggressive first operation gripping of rough bar work.

Vulcanized rubber between the hardened steel collet segments provides excellent protection against coolant and chip ingress. Counter boring and special profile shapes are available upon request.



Insert & Unlock DC Collet



Remove DC Collet

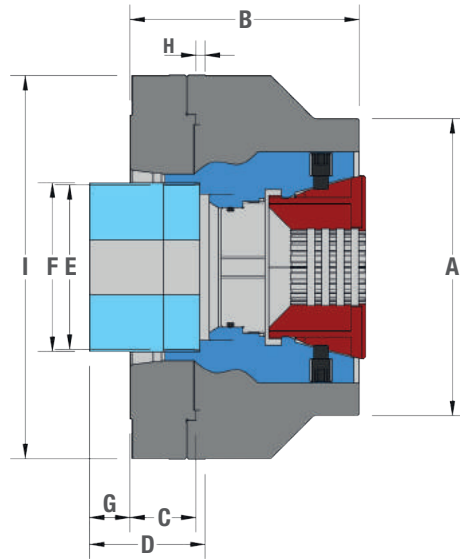


Insert DC Collet



Lock & Remove DC

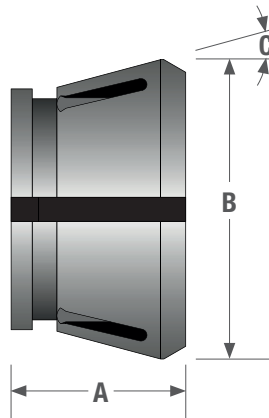
Fixed Length Series Power Collet Chuck for Bar Machining



KLAMP Type	DHF65			DHF80
Mounting	A5	A6	A8	A8
Part Number	DHF65A5	DHF65A6	DHF65A8	DHF80A8
Varibore Collet Type	DC65			DC80
Varibore Collet Gripping range*	Minimum	4		7
	Maximum	65		80
Varibore Collet Increments	1			1
A	162			175
B	125			137
C	35			239
D	60			49
E Maximum	M70 x 2.0	M85 x 2.0		M100 x 2.0
F	79	92		105
G Maximum	22			48.25
G Minimum	17.5			43.75
H	2			
I	210			
Sleeve stroke	4.5			4.5
Max. input force	kN	45		53
Max. Gripping Force	kN	105		96
Max. Speed	min ⁻¹	6000		5000
Net Weight	kg	27	27.2	26.5
Matching Kitagawa Cylinders	S1875 SS1770 SR1566			S2091 SS1881 SR1781



DC Quick Change Collets to Suit DHP65/DHF65/DRF65 Collet Chucks



DC65 Varibore Collets

- Round, Hexagon, Square or Emergency types available
- Please specify which gripping surface you require – Serrated or Smooth
- Clamping tolerance of +/- 0.5mm
- Counter boring and special profile shapes are available upon request

Dimensions (Metric)

Part No.	A	B	C
DC65	53	99.5	15°

DC65 Round Collets

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
4mm	DC65-R04	DC65S-R04
5mm	DC65-R05	DC65S-R05
6mm	DC65-R06	DC65S-R06
7mm	DC65-R07	DC65S-R07
8mm	DC65-R08	DC65S-R08
9mm	DC65-R09	DC65S-R09
10mm	DC65-R10	DC65S-R10
11mm	DC65-R11	DC65S-R11
12mm	DC65-R12	DC65S-R12
13mm	DC65-R13	DC65S-R13
14mm	DC65-R14	DC65S-R14
15mm	DC65-R15	DC65S-R15
16mm	DC65-R16	DC65S-R16
17mm	DC65-R17	DC65S-R17
18mm	DC65-R18	DC65S-R18
19mm	DC65-R19	DC65S-R19
20mm	DC65-R20	DC65S-R20
21mm	DC65-R21	DC65S-R21
22mm	DC65-R22	DC65S-R22
23mm	DC65-R23	DC65S-R23
24mm	DC65-R24	DC65S-R24

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
25mm	DC65-R25	DC65S-R25
26mm	DC65-R26	DC65S-R26
27mm	DC65-R27	DC65S-R27
28mm	DC65-R28	DC65S-R28
29mm	DC65-R29	DC65S-R29
30mm	DC65-R30	DC65S-R30
31mm	DC65-R31	DC65S-R31
32mm	DC65-R32	DC65S-R32
33mm	DC65-R33	DC65S-R33
34mm	DC65-R34	DC65S-R34
35mm	DC65-R35	DC65S-R35
36mm	DC65-R36	DC65S-R36
37mm	DC65-R37	DC65S-R37
38mm	DC65-R38	DC65S-R38
39mm	DC65-R39	DC65S-R39
40mm	DC65-R40	DC65S-R40
41mm	DC65-R41	DC65S-R41
42mm	DC65-R42	DC65S-R42
43mm	DC65-R43	DC65S-R43
44mm	DC65-R44	DC65S-R44
45mm	DC65-R45	DC65S-R45

Nominal Gripping Diameter	Serrated Part Number	Smooth Part Number
46mm	DC65-R46	DC65S-R46
47mm	DC65-R47	DC65S-R47
48mm	DC65-R48	DC65S-R48
49mm	DC65-R49	DC65S-R49
50mm	DC65-R50	DC65S-R50
51mm	DC65-R51	DC65S-R51
52mm	DC65-R52	DC65S-R52
53mm	DC65-R53	DC65S-R53
54mm	DC65-R54	DC65S-R54
55mm	DC65-R55	DC65S-R55
56mm	DC65-R56	DC65S-R56
57mm	DC65-R57	DC65S-R57
58mm	DC65-R58	DC65S-R58
59mm	DC65-R59	DC65S-R59
60mm	DC65-R60	DC65S-R60
61mm	DC65-R61	DC65S-R61
62mm	DC65-R62	DC65S-R62
63mm	DC65-R63	DC65S-R63
64mm	DC65-R64	DC65S-R64
65mm	DC65-R65	DC65S-R65

DC65 Hexagon Collets

Available from 7mm to 56mm across flats sides of the hexagon in 1mm increments. Part number is **DC65-X****. Please state which size you require, smooth or serrated gripping surface is available.

DC65 Square Collets

Available from 8mm to 46mm across flats sides of the square in 1mm increments. Part number is **DC65-S****. Please state which size you require, smooth or serrated gripping surface is available.

DC65 Emergency Collets

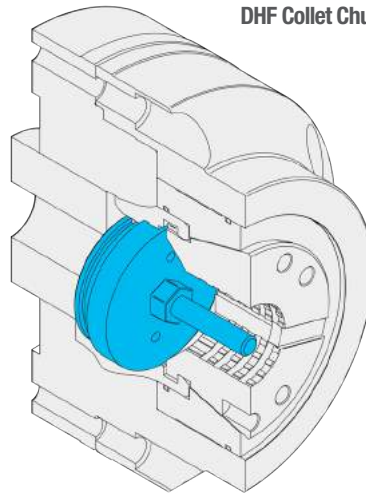
Available only with 8mm, 20mm or 30mm or 40mm pilot holes. Part number is **DC65-E****. Please state which size you require.

D Series Standard Accessories

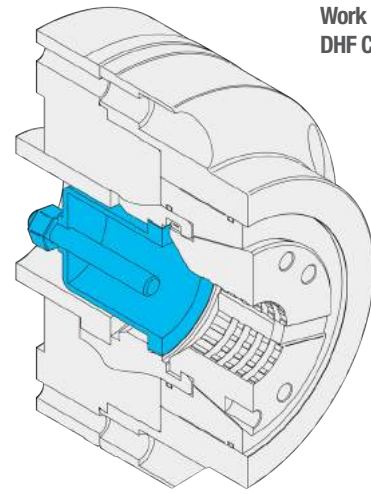
Work Stops

- Stops can be provided to allow for accurate z-axis positioning of short workpieces within the collet chuck.
- A threaded stud is provided for easy adjustment to suit your work piece
- All stops are easily installed from the front face utilising a side bolt to hold the stop securely in place.
- These stops can be installed on all DHP & DHF series collet chucks.
- Full length spindle stops can also be provided for long work pieces, these can utilise the entire length of your machine spindle, please contact your Klamp supplier to see the maximum length stop your machine could accommodate.

Work Stop on a DHF Collet Chuck



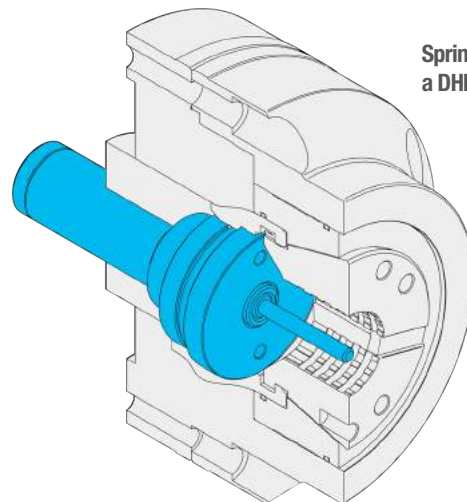
Additional Length Work Stop on a DHF Collet Chuck



Spring Ejectors DHF Series Only

- Standard spring ejectors for in the DHF series are use for second-spindle operations to expel finished workpiece into the parts catcher.
- All spring ejectors are easily installed from the front face utilising a supplied key
- Many variants of spring ejector are available to suit your production process.
- Full length hydraulic or pneumatic ejectors can also be provided for long work pieces, this can utilise the entire length of your machine spindle, please contact your Klamp supplier to see the maximum length stop your machine could accommodate.

Spring Ejector on a DHF Collet Chuck



Collet Changing Device D Series Collet Chucks

- Easy to use device to allow DC Collets to be removed or installed.
- Simply insert the steel pins into the Collet face holes and squeeze the trigger to collapse the DC Collet.
- Availabel in both manual and pneumatic versions.

Part Number	To Suit		Type
	DHP Series	DHF Series	
DCD42	DHP42	-	Manual
DCD52	DHP52	-	Manual
DCD65	DHP65	DHF65	Manual
DCD80	DHP80	DHF80	Pneumatic

